

Split 2











Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 24867 A Estimate Number : 10699 P.O. Number : NIA This Issue : 11/18/2005 S.O. No. : NIA Prsht Rev. : NC First Issue : NIA Type : LANDING GEAR Previous Run : NIA Written By : <u>See Comment below</u> Checked & Approved By : <u>See comment below</u> Comment : Est. 19 QC3 Inspect Powder Coat	Drawing Name : AFT TUBE ASSEMBLY Part Number : D3391025 Drawing Number : D3391 REV B Project Number : NIA Drawing Revision : B Material : NIA Due Date : 12/20/2005 Qty: 5 Um: Each
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Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D6014090	ALUMINUM EXTRUSION
<div style="display: flex; justify-content: space-between;">   </div> <p>Comment: Qty.: 1.0000 f(s)/Unit Total : 5.0000 f(s) ALUMINUM EXTRUSION Pick: Qty Part Number Description Batch 1 D6014-090 Extrusion <u>B24315</u> <u>J. G 05/11/24</u> 5 Identify as D3391-3</p>		
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
<div style="display: flex; justify-content: space-between;">   </div> <p>Comment: MORI SEIKI CNC LATHE LARGE Turn as per Folio FA Rev: <u>C</u> & Dwg D3391 Rev: <u>NIA</u> <u>J. G 05/11/30</u> 5</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<div style="display: flex; justify-content: space-between;">   </div> <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J. G 05/11/30</u> 5</p>		
4.0	BAND SAW <u>HAAS</u>	BAND SAW
<div style="display: flex; justify-content: space-between;">   </div> <p>Comment: BAND SAW <u>HAAS</u> Machine as per Folio FA Rev: <u>AA</u> & Dwg D3391 Rev: <u>C</u> Drill aft cap holes per Dwg D3391 using DT8803 Deburr <u>BG 05.12.04</u> 5</p>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<div style="display: flex; justify-content: space-between;">   </div> <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>BG 05.12.04</u> 5</p>		



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Order: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 24867

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

7.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3391

NP 05-12-30 (2)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill and c' sink wearshoe holes as per Dwg D3391

NP 06-1-7 (2)

C'sink holes for float bag (4 holes per side) as per Dwg D3391

NP 06-1-7 (2)

Deburr

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

NP 06-1-7 (1)

g.m 06-1-7 (1)

12.0 AESS10KB366

Inventory



Comment: Qty.: 14.0000 Each(s)/Unit Total: 70.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

m17905

FC 06 01 10

13.0 NAS1330C3KB166

Rivnut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivnut

Pick:

FC 06 01 10

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number

Description Batch

8

NAS1330C3KB166

Insert

m19354

FC 0601 10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

POC 01.12

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/01/13 (5)

SP / 06/01/12

Job Completion



